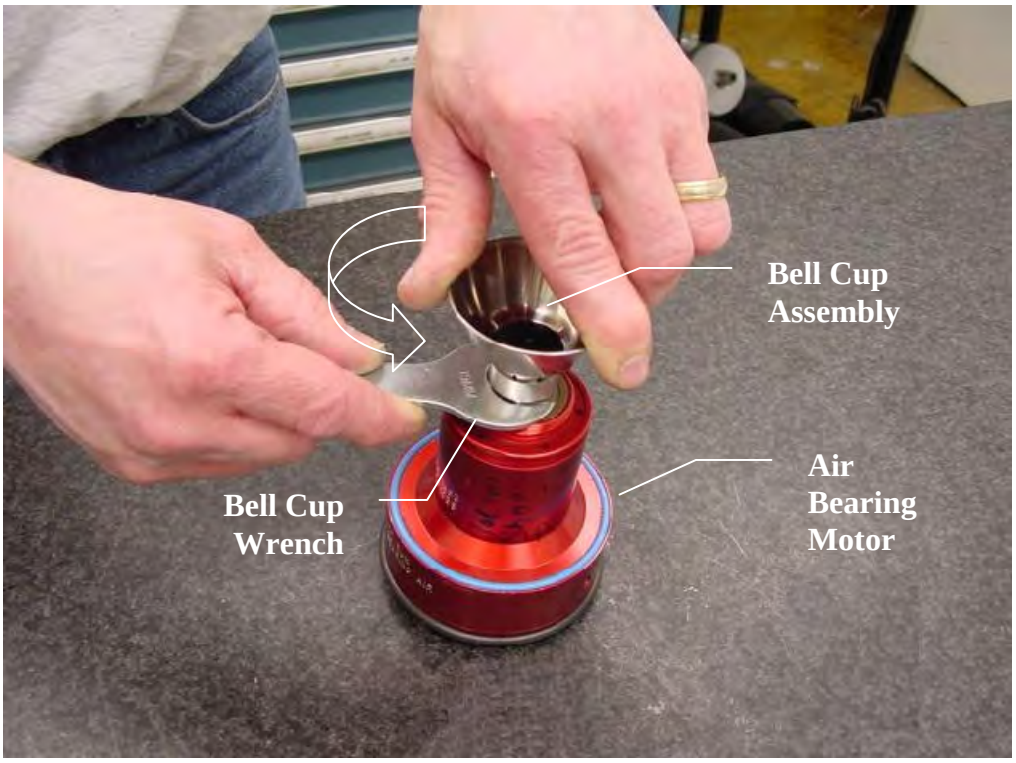
ENGINEERING NOTICE

Date: **4/21/06**

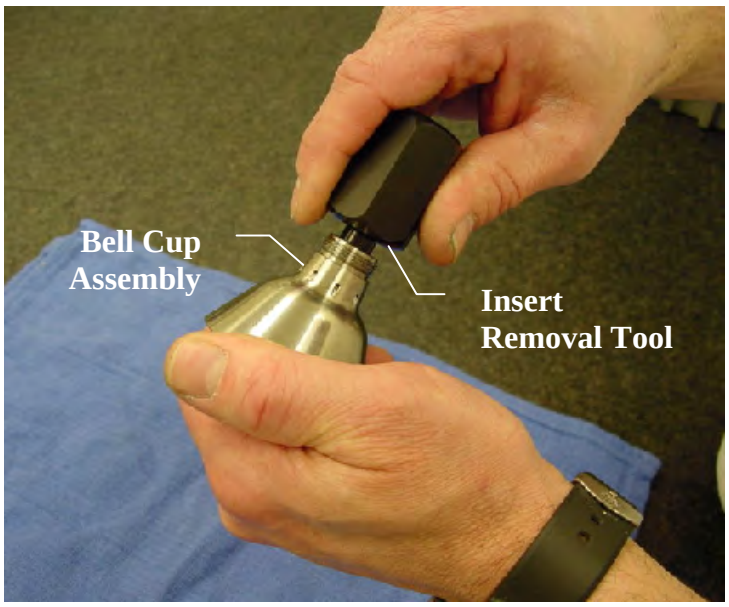
Subject: **25-4C10K Bell Cup Cleaning Procedures**

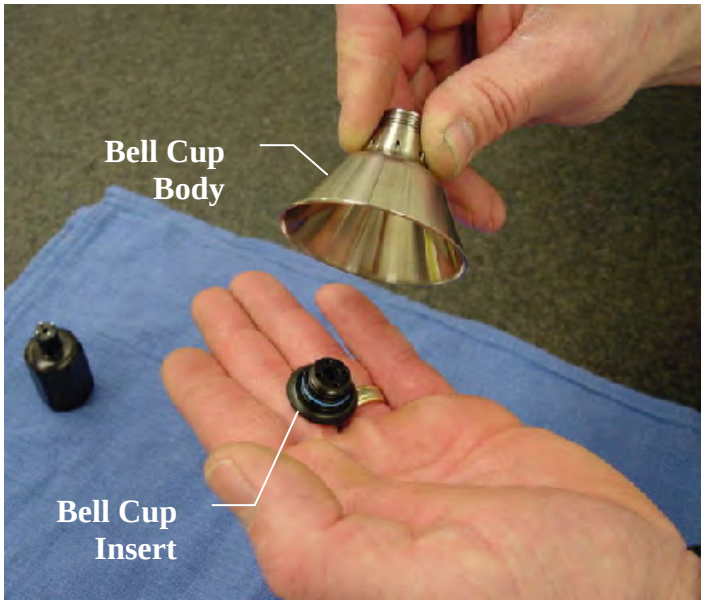
Procedure:

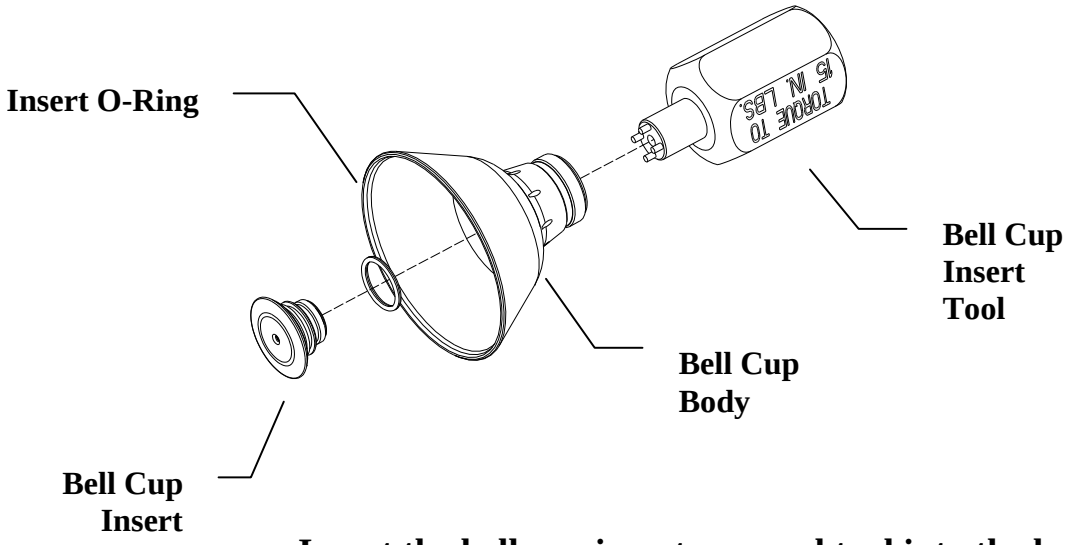
1. **Carefully remove the bell cup from the atomizer (air bearing motor) by holding the atomizer shaft stationary with the proper tooling and unscrewing, counterclockwise, the cup.**



2. **Place the cup on a surface that will not damage the cup and carefully remove the cup's insert assembly. The insert assembly may contain more than one piece so exercise caution when removing the bell cup's center components. Use the proper tooling.**



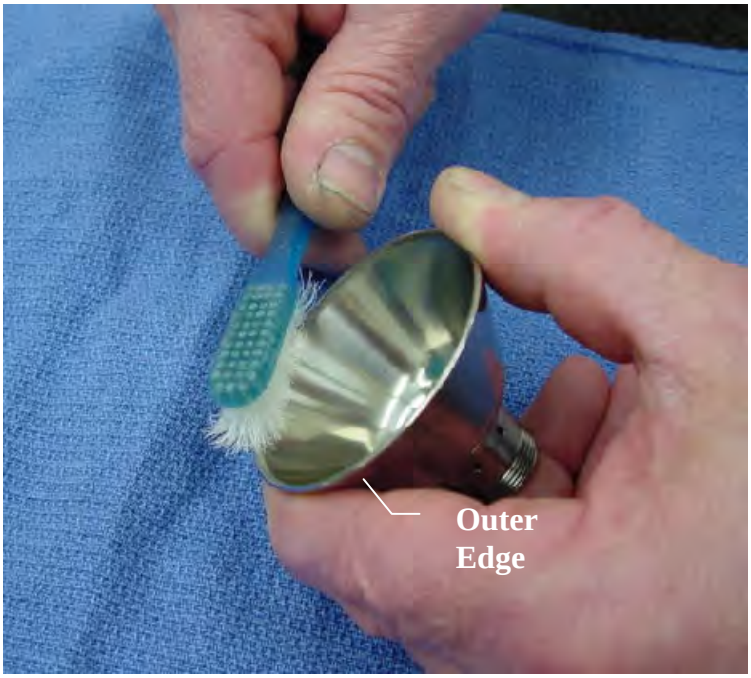




Insert the bell cup insert removal tool into the back of the bell cup as shown above. Turn the wrench clockwise to loosen the insert from the bell cup body.

3. **Inspect all components for damage (including o-rings) and replace as necessary. Carefully inspect the outer edge of the bell cup (where the paint exits) for damage.**

4. **Use only soft bristle brushes and lint-free cloths to clean the cup. Remove all debris from the entire cup, paying particular attention to any threads on the cup. Depending upon whether the cup is spraying solvent or water bourn paint, either solvent or di-water may be used to clean the cup. Do not soak the o-ring in aggressive solvents for more than one hour.**



5. **Carefully re-assemble the cup with the proper tooling. Care must be taken when reinstalling the bell cup insert assembly into the bell cup body so as not to cut the o-ring on the insert. With a torque wrench attached to the insert tool, insert the bell cup insert tool into the back of the cup and turn the insert counter clockwise (when viewed from the back of the cup). Set the torque wrench to 15 in-lbs. The insert will come to a stop when inserted properly.**